

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-029850**Date Inspected:** 16-Jul-2013**Project Name:** SAS Superstructure**OSM Arrival Time:** 730**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1600**Contractor:** USA Hoist**Location:** Crest Hill, IL.**CWI Name:** None present**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower Elevator Components**Summary of Items Observed:**

This Quality Assurance Inspector (QAI) arrived at the USA Hoist production facility for the purpose of performing inspections of Tower Elevator items to the requirements CC0-085, Standard Specification and Special Provisions.

This QAI observed the fit-up and tack welding of the Bearing Top Isolator weldment Top assembly as per the referenced drawings identified as 916232-11 and 916232-32. The beveling of the plates was verified for both the Left-Hand and Right-Hand assemblies which allows a flush vee-groove weld to be effected.

The press-fitting of alignment bushings into machined end-pockets of Tower Masts is in progress but not complete.

The attachment bonding is in progress of the rubber seal cushion strips between the Elevator Cab frame and the window framing.

**Summary of Conversations:**

This QAI spoke with Projethact Manager Tim Moran, inquiring as to the results of the powder-coating by Americana of the sample Elevator Landing angle which was re-galvanized by MW Galvanizing. Mr. Moran expressed that the powder-coating of the angle was reported by Americana as having an unacceptable, blistered surface finish.

**Comments**

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or

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## WELDING INSPECTION REPORT

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remedial efforts please contact Gary Thomas (916) 764-6027, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Morris, Monty	Quality Assurance Inspector
<b>Reviewed By:</b>	Foerder, Mike	QA Reviewer

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